

WHAT IS CLAIMED IS:

1. A rotary cutter for use in cleaning pipes, comprising:
a support housing having a plurality of skid fins extending radially outward therefrom at different angular positions about the support housing defining a radial periphery;
a rotor carried by the support housing which rotates relative thereto;
a motor supported by the support housing adapted to rotate the rotor;
a plurality of linkages mounted to the rotor extending radially outward therefrom, the linkages being made of a first material; and
at least one end bit comprising a surface engaging mass that comprises a second material that is harder than the first material, the at least one end bit being attached to the chain root cutter by at least one of the plurality of linkages, the at least one end bit centrifugally extending beyond the radial periphery when rotated.
2. The rotary cutter of claim 1 wherein, said at least one end bit further comprises a support structure, the support structure adapted to attach the end bit to said linkages and said second material is soldered to the support structure.
3. The rotary cutter of claim 1, wherein said plurality of linkages comprises chains.
4. The rotary cutter of claim 2, wherein said support structure comprises a chain link.
5. The rotary cutter of claim 2, wherein said support structure comprises a channeled member secured to the linkage.
6. The rotary cutter of claim 2, wherein said second material comprises carbide in the form of a plurality of carbide chips soldered together.
7. The rotary cutter of claim 6, wherein said carbide chips have a mean maximum dimensional size of less than about 6 millimeters.
8. The rotary cutter of claim 6, wherein said carbide chips have a mean maximum dimensional size of between about 1 millimeters and about 3 millimeters.

9. An end bit for a rotary cutter for use in cleaning pipes, comprising:
a support structure of a first metal material for attaching the end bit to a rotor of a rotary cutter;
a plurality of carbide chips; and
solder material securing the carbide chips together in a surface engaging mass and securing the carbide chips to the support structure.
10. The end bit of claim 9, further comprising a linkage for attaching the end bit to a rotor of a rotary cutter, having said support structure attached thereto.
11. The end bit of claim 10, wherein said support structure is welded to said linkage.
12. The end bit of claim 10, wherein said linkage comprises a chain.
13. The end bit of claim 9, wherein said carbide chips have a mean maximum dimensional size of less than about 6 millimeters.
14. The end bit of claim 9, wherein said carbide chips have a mean maximum dimensional size between about 1 and about 3 millimeters.
15. The end bit of claim 9, wherein said support structure comprises a chain link.
16. The end bit of claim 9, wherein said support structure comprises a channeled member.
17. A method for improving the operation of a rotary cutter for use in cleaning pipes, the rotary cutter comprising a support housing having a plurality of skid fins extending radially outward therefrom at different angular positions, a rotor carried by the support housing for rotation relative thereto, the rotor adapted to carry a plurality of linkages, and a motor supported by the support housing adapted to rotate the rotor, the method comprising:
providing an end bit comprising a plurality of chips secured together on a support structure, the chips being of a first material harder than the support structure; and

linking the end bit to the rotor with one of the linkages, wherein the plurality of chips provide a surface engaging mass facing radially outward and away from the rotor during rotation of the rotor.

18. The method for improving the operation of the rotary cutter of claim 17, wherein said providing comprises soldering said chips to said support structure.

19. The method for improving the operation of the rotary cutter of claim 18, wherein said support structure is a chain link.

20. The method for improving the operation of the rotary cutter of claim 18, wherein said support structure comprises a channeled member.

21. The method for improving the operation of the rotary cutter of claim 17, wherein said chips comprise carbide.